Work Order ID 74. Tuesday, October 04, 2011 9									Page 1
Item ID: D3404-1 Revision ID:		A	ccept			s	etup Start Stop		
Item Name: GHW Lug Start Date: 9/30/2011 Required Date: 10/14/2011 Reference:	Start Qty: 40.00 Req'd Qty: 40.00			Cust Item II Customer:) :	·			
	nn: MLJ	•			te:	K	tun Start Stop		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	•	Reject Number	Insp. Stamp
Draw Nbr Rev	vision Nbr						,		
D3404 Rev	/ C								
Bandsaw Jeaspa Bandsaw	BAND SAW Memò Cut blank: 2.7	50" long	0.00 0.00 ml	_ u/10/14		_40	_ /	<u> </u>	·
110 HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL Memo		0.00 0.00 D3404□Dwg Rev:	/F.K . 11	/10/14	47	<u>\$</u>	· .	· · ·
HAAS CNC Vertical machine #1	AA []2-	Deburr						a and	*
120 OC	QC2- Inspect parts off mad	hine FAI/FAIB	0.00	nl/F.K.	11/10/14	47	_	. ,	
Quality Control	wieino		3.00						

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Dart	Aeros	pace	Ltd
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W/O:			WORK ORDER	CHANGES				
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
- '					,			
Part No):	PAR #:	Fault Category:	NCR: Ye	s No DQ	A:	Date: _	
		· ·	Disposition:		Closed:		Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		D 1111110		Corrective Action Section B		Verification	Approval	Approval	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
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Page 2

Tuesday, October 04, 2011 9:58:12 AM

Item ID:

D3404-1

GHW Lug



Setup Start



Stop



Item Name: **Start Date:**

Revision ID:

Required Date: 10/14/2011

9/30/2011

Start Qty: 40.00

Req'd Qty: 40.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:_____

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Accept

Date:

Date:

Run

Stop

Start



Sequence ID/ **Work Center ID**

130

Quality Control

Operation Description

QC8- Inspect parts - second check

Tool ID

Tool # Plan Accept Code Qty

Reject Qty

Reject Insp. Number

Stamp

Memo

140

Packaging Packaging

Memo

Identify as per dwg & Stock Location: WA

0.00

0.00

150

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

M/10/19 90)

Dart Ae	rospace	e Ltd								
W/O:			WO	RK ORDER CHANG	SES					
DATE	STEP	PRO	OCEDURE CHAN	GE	1	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No):	PAR #:	Fault Categ	ory:	_ NCR:	Yes N	o DQ	\ :	Date: _	·
	F	Resolution:	Disposition	:	QA: N	VC Clos	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE ((NCR)				
<u> </u>	T	Description of NC		Corrective Action Sec	ction B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
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Picklist Print

Tuesday, October 04, 2011 9:58:16 AM

Work Order ID: 74551

Parent Item:

D3404-1

Parent Item Name: GHW Lug



Start Date: 9/30/2011

Required Date: 10/14/2011

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev:A□05.09.01□New issue□KJ/JLM□;**

IPP rev B 09.01.28 new geometry rev.C

EC verified by:DD

	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	<u> </u>
÷	M304B0.750X2.500		Purchased	No			100	f	20.5714	0.2291	9.646316				_
					,										

304 BAR .750 X 2.50

Location MAT050

Loc Qty Loc Code 20.5714

10.8 9.7714

Dart Aerospace Ltd

W/O:			W	ORK OR	DER CH	ANGE	S					
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Part No):	PAR #:	Fault Ca	tegory:		•.	NCF	R: Yes N	lo DQA:		Date: _	
	R	esolution:	 Disposit	ion:			QA:	N/C Clo	sed:		Date: _	
NCR:		V	ORK OR	DER NON	I-CONF	ORMA	NCE	(NCR)				
DATE	STEP	Description of NC		Correctiv		Section	n B	Sign &	Verifica		Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	ACI	on Descri Chief Eng	ption		Date	Section	ı C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	74551
Description: GHW Lug	Part Number:	D3404-1
Inspection Dwg: D3404 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	P	rototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.510	+0.008/-0.001	\$10	\		Vern Fk-04	
R0.65	+/-0.030	.65	\		',	,
0.125	+/-0.010	0/26	V		*,	
0.500	+/-0.010	.500	7		. • ,	
2.14	+/-0.030	2-136	\		٠,	
1.30	+/-0.030	1,300	\ \		Δĵ	
R2:30	+/-0.030	7.30	٧		radgange	
1.14	+/-0.030	1,145	V		Verntk-04	
2.58	+/-0.030	2,872	\		1)	
				:		
			À			
						4-2
						24. 1.

Measured by:	Kt / and	Audited by:	D.A	Prototype Approval:	N/A
. Date:	11/10/14	Date:	11/10/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.04.12	New Issue	KJ/JLM , N	7/
В	09.05.04	Dimensions updated per Dwg Rev. C	KJ/DD	ful

Dart Aerospace Lt	.a
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W/O:			WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No):	PAR #:	Fault Categ	ory:	_ NCR: Yes	No DC	A:	Date: _			
	R	esolution:	Disposition	QA: N/C C	osed:		Date:				
NCR:	1000		WORK ORDE	R NON-CONFORMA	ANCE (NC	?)					
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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

SHOP COPY **RETURN TO ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER 14551 M.L.J

11/10/04

D3404-1 GHW LUG

DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20. AJS 08.12.02 В UPDATE M-SPEC PH 05.06.14 Α NEW ISSUE 05.03.08 REV. DESCRIPTION BY DATE

DESIGN DART AEROSPACE LTD AUS DRAWN DRAWING NO. CHECKED REV. C D3404 MFG. APPR. SHEET 1 OF 2 APPROVED TITLE SCALE **GHW LUG** DE APPR. NTS

DATE 08.12.02 COPYRIGHT @ 2005 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COND
HOT TO BE USED FOR ANY PURPOSE OR COPYED OR COMMENCATED TO ANY OTHER PER

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304B

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED

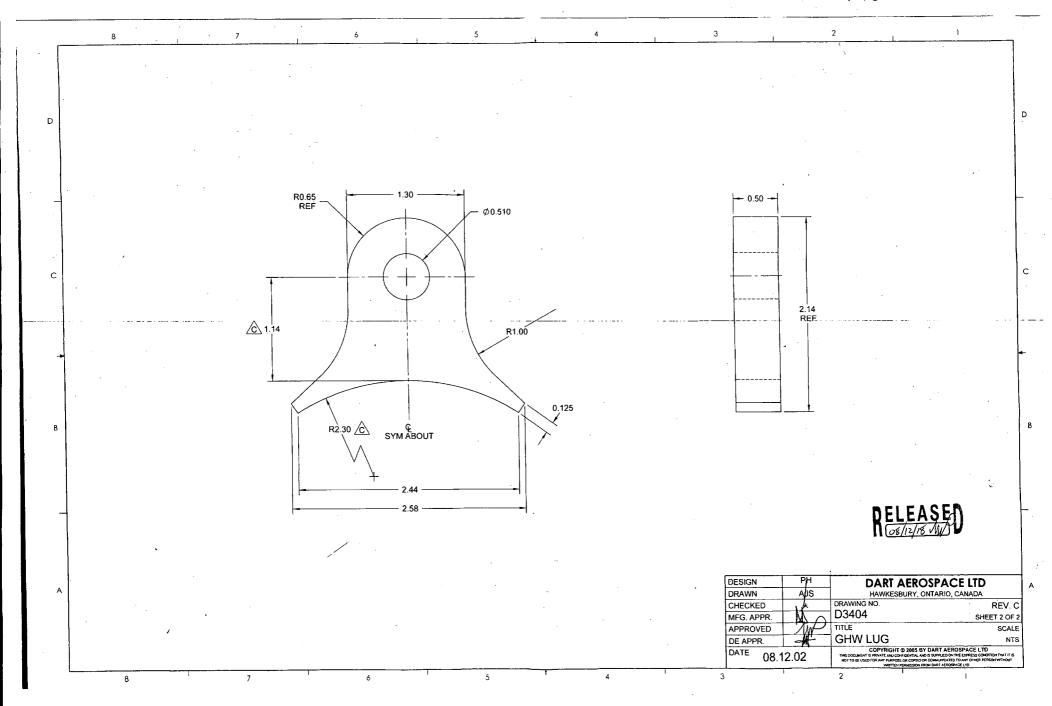
5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: 0.34 lbs

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Dart Aerospace	e L	_td
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W/O:	 		V	VORK ORDER CHANG	ES					
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	Resolution:									
NCR:				DER NON-CONFORMA						
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